



SPLIT

Work Order ID 51923-1



Wednesday, September 09, 2009 11:35:25 A

Item ID: D2573 Accept  Setup Start 
Revision ID: E Stop 
Item Name: Saddle, Aft Out 205
Start Date: 9/11/2009 Start Qty: 6.00 ~~9.00~~  Cust Item ID:
Required Date: 9/18/2009 Req'd Qty: 6.00 ~~9.00~~  Customer:
Reference:

Approvals: Process Plan: RC2 Date: 09-9-09 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	Rev E								

100  HAAS CNC VERTICAL MACHINING #1 0.00 OK 09/09/27 9

HAAS 1 Memo
HAAS CNC vertical machine #1 Program Batch No. 51923 Double check by: mv ☐ 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-
Machine Step No 3 per Folio FA051 and insp

110  CONVENTIONAL MILLING MACHINE 0.00 OK 09/09/27 9

Mill Conv Memo
Conventional Milling Machine Machine keyway as per dwg D2573 & D2574

120  QC2- Inspect parts off machine FAI/FAIB 0.00 OK 09/09/27 9


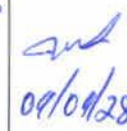

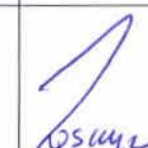

QC Memo
Quality Control

↑


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2573 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>51923</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-09-28	100	1 saddle the bushing hole dimension is off 0.015" from nominal. Origin error. cc: operator error.		performed fit test assy onto the skid tube & fits really good. No twist or torque.	 09/09/28	 09-09-28		 09-09-28

NOTE: Date & initial all entries

Work Order ID 51923

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Item ID: D2573

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft Out 205

Start Date: 9/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A
09/09/28

9 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

JL 09/09/26

9 0

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M112260

=> JL 09/09/28

(X9) 9

START TIME: 10:30pm FINISH TIME: 11:00pm OVEN TEMPERATURE: 326°F

Work Order ID 51923

Wednesday, September 09, 2009 11:35:25 A



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Item ID: D2573

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft Out 205

Start Date: 9/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

*Pl 24-09-08.**(9)*

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Pl 24-09-08 (9)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*09/09/29**MF 09-09-29*

Picklist Print

Wednesday, September 09, 2009 11:35:30 AM

Page 1

Work Order ID: 51923



Parent Item: D2573RevE



Parent Item Name: Saddle, Aft Out 205

Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured	No			100	Each	0.0000	6.0000			

Saddle Billet

Batch# B46412 9 ent 09/09/27

DART AEROSPACE LTD	Work Order: 51923
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.002		
F	0.490	0.510	CHECK NCR	.504	.485	.503	.509		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.500	.501	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.568	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.127	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.252	.251	.251		
S	0.115	0.135		.121	.121	.120	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.239	.239	.240		
W	0.115	0.135		.127	.126	.125	.130		
X	0.308	0.313		.310	.310	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.635	.632	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.243	.245		
AE	1.500	1.520		1.515	1.518	1.518	1.515		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.247	.248	.249		
AI	2.000	2.020		2.003	2.004	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	09/04/25

Audited by:	H A
Date:	09/07/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	51923
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.003	8.004		
F	0.490	0.510		.501	.504	.503	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.502	.501	.502		
J	1.174	1.184		1.179	1.178	1.179	1.178		
K	0.558	0.578		.567	.568	.566	.568		
L	1.174	1.184		1.179	1.178	1.179	1.178		
M	1.365	1.375		1.370	1.370	1.369	1.370		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.124	4.123	4.124	4.124		
P	0.115	0.135		.127	.128	.127	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.257	.257	.253		
S	0.115	0.135		.121	.122	.123	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.227	3.227		
V	0.230	0.250		.236	.238	.237	.236		
W	0.115	0.135		.130	.130	.132	.128		
X	0.308	0.313		.309	.310	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.359	.358	.366		
AA	0.470	0.530		.500	.500	.500	.250		
AB	0.615	0.635		.635	.635	.635	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.244	.246	.245		
AE	1.500	1.520		1.516	1.512	1.513	1.518		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.245	.248	.248	.248		
AI	2.000	2.020		2.004	2.001	2.004	2.007		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	mf
Date:	09/09/27

Audited by:	N.A
Date:	09/09/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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				1/9	2/10	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.005				
F	0.490	0.510		.500	.501				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.504	.502				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.570	.569				
L	1.174	1.184		1.178	1.178				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.499	2.499				
O	4.119	4.129		4.125	4.125				
P	0.115	0.135		.129	.129				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.253	.252				
S	0.115	0.135		.129	.129				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.228	3.228				
V	0.230	0.250		.240	.241				
W	0.115	0.135		.133	.135				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.365	.362				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.629	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.248	.249				
AE	1.500	1.520		1.512	1.509				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.276	.270				
AH	0.240	0.260		.257	.257				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	Am
Date:	09/09/27

Audited by:	B.A
Date:	09/09/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
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